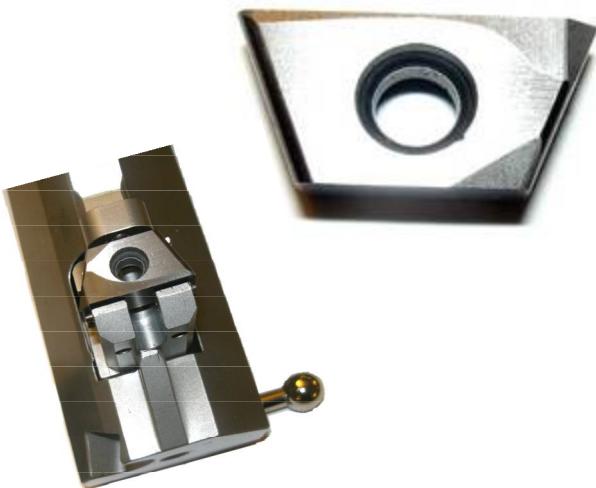


Metal insert - variable cutting edge

A08-350

This type of inserts with variable cutting edge and angle are usually screwed circularly on milling heads and used for high speed machining. The variable cutting angle along the insert profile allows to use the same tool for roughing and finishing the processed material without changing the milling head between manufacturing steps.

We grind a negative profiled chamfer using a periphery 1A1 wheel on the long side of trapezium.



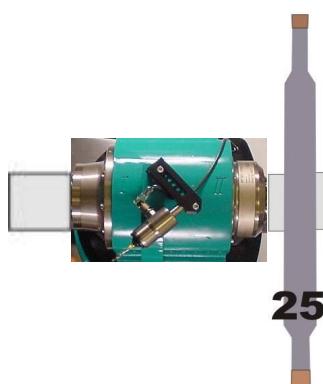
1. Cycletime for Production

Tool specifications					
Length of cutting edge: 25 mm, DXF-profile Material CARBIDE					
Operations	Load	Profile	Probe	Rotate	Profile
Feed [mm/Min]	9000	100	100	9000	100
Power [kW]	1	1	1	1	1
Cutting feed [m/s]		80	300		80
Used wheels		25			25
Grinding time [s]	10	38	10	10	38
Total cycle time	1 Min 47				

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

25 1A1 Ø300 D64



3. Machine and Software Requirements

Machines: 6 axes CNC grinder: SIRIUS HPM

Control: Fanuc 160i

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 4.3, DXQ

responsible engineer: SIW 21.01.2009

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